

Work Order ID 57836

April 16, 2010 11:48:08 AM



Page 1

Item ID: D2506

Accept



Setup Start



Revision ID:

Item Name: Label Plate

Stop



Start Date: 16/04/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *10-4-10*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2506

Rev F

100

0.00



Waterjet

FLOW WATER JET

Memo

0.00

FLOW CNC Waterjet

304. 040

1-Cut as per Dwg D2506
Deburr if necessary

☐ Dwg Rev:

F

☐ Prog Rev:

F

☐ 2-

10-4-10

(5)

110

0.00



QC

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

Quality Control

10-4-10

120

0.00



QC

QC8- Inspect parts - second check

Memo

0.00

Quality Control

Siolay/bz

(x5)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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April 16, 2010 11:48:08 AM

Page 2

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Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

1-Form as per dwg D2506

Sp 10/04/29

(S)

0

140

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

S. 10/04/29

(45)

150

0.00



Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

Packaging

Basket cell

10/05/03 (5x)

W/O:		WORK ORDER CHANGES					
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Page 3

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Cust Item ID:

Required Date: 23/04/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/04

MF

10-5-4

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

April 16, 2010 11:48:13 AM

Page 1

Work Order ID: 57836



Parent Item: D2506

Parent Item Name: Label Plate

Start Date: 16/04/2010

Required Date: 23/04/2010

Comments: IPP B ☐ 01.06.08 ☐ Now laser cut ☐ EC ☐

Start Qty: 5.00

Required Qty: 5.00

IPP C 06.12.13 ecn 822 ec

IPP Rev:D 08-12-01 rev.F as per dwg DD verified by:

Component Item ID/	Replacement	Mfg/	Bin	Primary	Last	Route	Unit of	Qty on	Remaining	Qty	Date	Status
M304S20GA		Purchased	No			100	sf	52.3000	6.4211			



304/316 .040 Sheet



B10-4-26

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT20

52.3

112885

5

113062

47.3

113062

5

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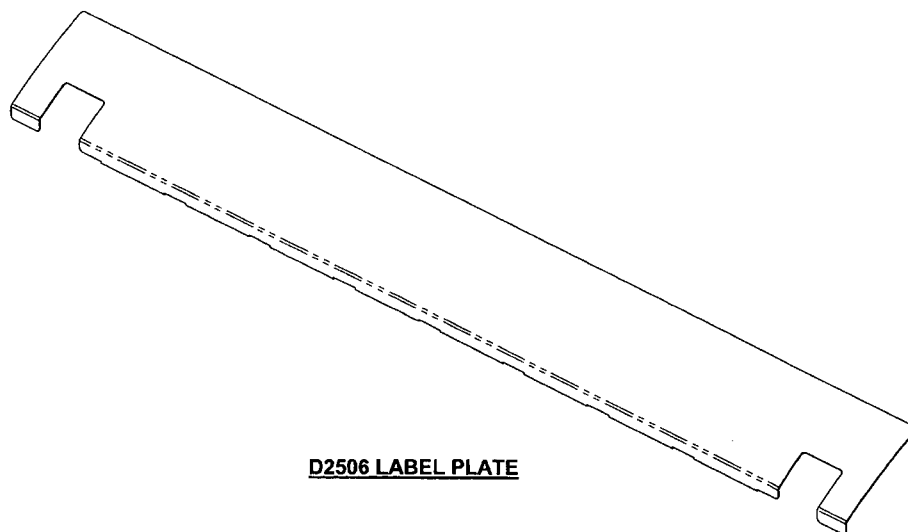
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D2506 LABEL PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 57836

BS 10-1-16

RELEASE
08/11/16 MB

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 \triangle
REF. DART SPEC. M304S20GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.92 lbs

F	REDRAWN IN SOLIDWORKS TO CURRENT STANDARD AND TRANSFERRED TO "B" SIZE FORMAT. UPDATED NOTE 1 (ZN A6-1); ADDED DETAIL A (ZN C8-2); 124" \pm 1" WAS 127" (ZN A4-2). REASONS: EASE MANUFACTURING WITH CORRECTION OF BEND AND ADDITION OF INTERMITTENT WELDING LOCATORS	MB	08.09.23
E	REMOVE 10" BEND; ADD NOTES: 127" WAS 126"	CB	06.11.20
D	32.63 WAS 32.25; 1.31 WAS 1.50	KE	99.10.04
C	RE-DESIGN OF LABEL PLATE	MM	96.09.04
B	RE-DESIGN OF LABEL PLATE	MM	96.06.18
A	NEW ISSUE	KH	95.11.26
REV.	DESCRIPTION	BY	DATE
DESIGN	B/W	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>BS</i>		
CHECKED	<i>BS</i>	DRAWING NO.	REV. F.
MFG. APPR.	<i>BS</i>	D2506	SHEET 1 OF 2
APPROVED	<i>BS</i>	TITLE	SCALE
DE APPR.	<i>BS</i>	LABEL PLATE	NTS
DATE	08.09.23	<small>COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

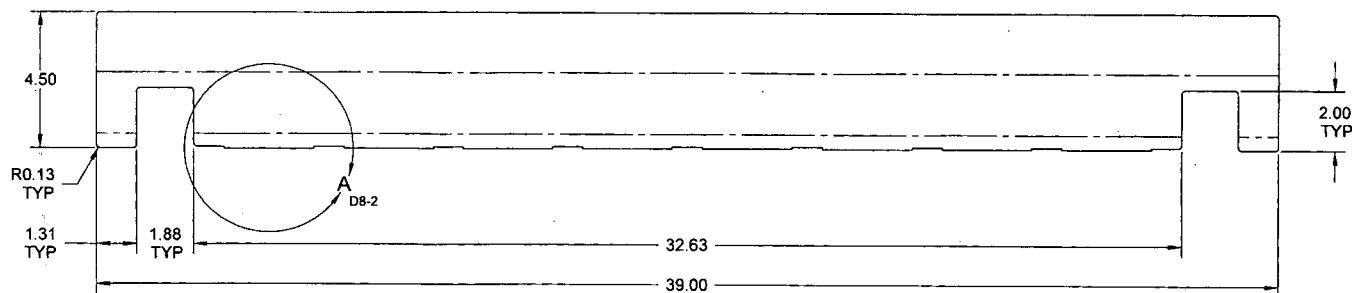
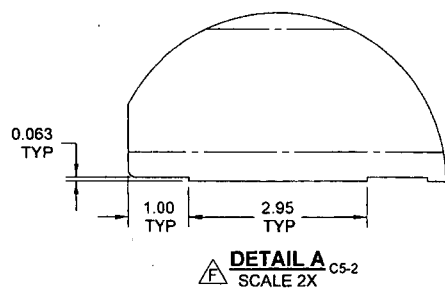
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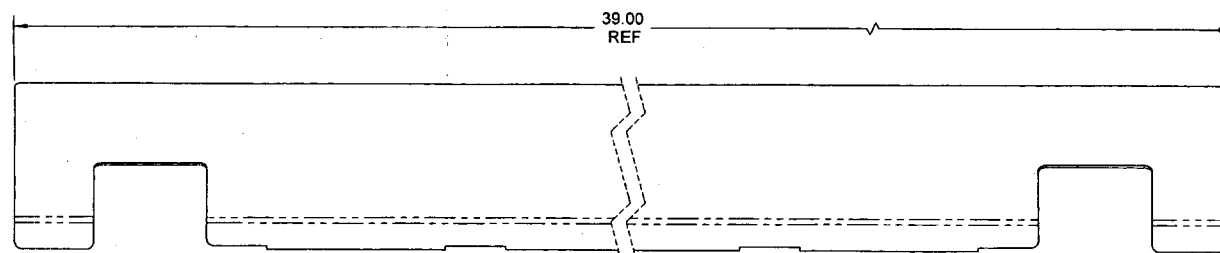
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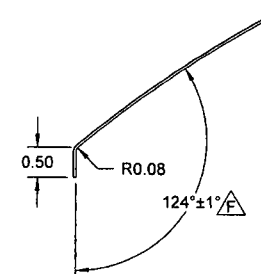


D2506-F LABEL PLATE
(FLAT PATTERN)

w/o 57836



D2506 LABEL PLATE
(MAKE FROM D2506-F)



RELEASED
08/11/18

DESIGN	BY	DART AEROSPACE LTD	
DRAWN	BY	HAWKESBURY, ONTARIO, CANADA	
CHECKED	BY	DRAWING NO. D2506	REV. F
MFG. APPR.	BY	SHEET 2 OF 2	
APPROVED	BY	TITLE	SCALE
DE APPR.	BY	LABEL PLATE	NTS
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